

Debin 750

Work Order ID 84725

84725

Page 1

May-22-12 1:05:51 PM

Item ID: D3723-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bushing

Start Date: 22/05/2012 Start Qty: 100 *1*

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 100 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/05/22 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3723	Rev A
-------	-------

100

0.00

100

CONVENTIONAL LATHE

DAS
14
2-89

12/07/29

27

0

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn as per dwg D3723

FOLIO REV: AA

DWG REV: 1

DEBURR

105

0.00

105

QC2- Inspect parts off machine FAI/FAIB

DAS
14
2-89

12/07/29

27

0

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84725

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Page 2

May-22-12 1:05:51 PM

Item ID: D3723-1 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 22/05/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 03/07/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		24 12.7.29		27	4		
120 *120* Packaging Packaging	Identify as per dwg & Stock Location: <u>064</u> Memo	0.00 0.00						6/12/11/30 (27)	
130 *130* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						12/7/31	

ML 12/07/30

W/O:		WORK ORDER CHANGES					
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Picklist Print

May-22-12 1:05:55 PM

Page 1

Work Order ID: 84725

84725

Parent Item: D3723-1

D3723-1

Parent Item Name: Bushing

Start Date: 22/05/2012

Required Date: 03/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev. A 08.02.15 New issue EC
IPP Rev:B 08-02-27 rev.A as per ecn 1139 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.750		Purchased		No		100	f	210.1750	0.02	0.021053			

MDFI RINR0 750

**

Delrin Round Bar 0.75"

Location	Loc Qty	Loc Code
MAT055	210.175	
116183	2.4	
117273	1.555	
117322	0.94	
120722	5.28	
→ 121783	200	

625 210.175 12/07/29

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

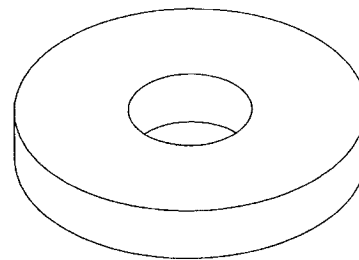
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO. 24725 MLJ
12/05/22



D3723-1 BUSHING

RELEASED
 08.02.11

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, ROD
 (REF DART SPEC M-DELRIN-R)
 OR DELRIN II 150E OR ACETRON GP ACETAL, BAR
 (REF DART SPEC M-DELRIN-B)
 OR DELRIN II 150E OR ACETRON GP ACETAL, SHEET
 (REF DART SPEC M-DELRIN-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs APPROX

A		NEW ISSUE		DESCRIPTION		AJS	08.02.11
REV.						BY	DATE
DESIGN							
DRAWN							
CHECKED							
MFG. APPR.							
APPROVED							
DE APPR.							
DATE							

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3723** REV. A
 SHEET 1 OF 2
 TITLE **BUSHING** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

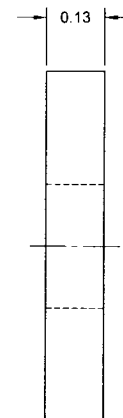
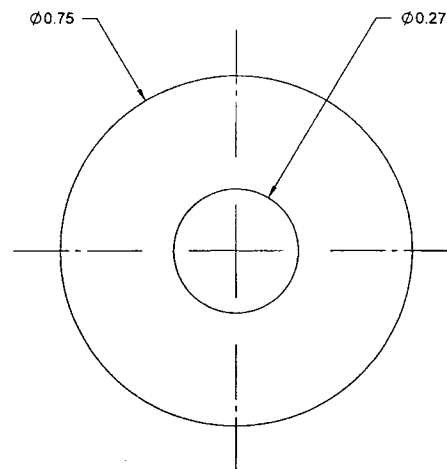
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NOTE: Date & initial all entries

84725



D3723-1 BUSHING

RELEASED
16 080225

DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JS	
CHECKED	JS	DRAWING NO. D3723 REV. A
MFG. APPR.	JS	SHEET 2 OF 2
APPROVED	JS	TITLE BUSHING SCALE 4:1
DE APPR.	JS	
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